

Work Order ID 67861

Friday, April 01, 2011 1:41:35 PM

*Ship by wedn*

Page 1

Item ID: D2724-042

Accept



Setup Start



Revision ID:

Stop



Item Name: 206L Step Assembly

Start Date: 4/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*WFC*Date: *11-04-01*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2724

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2724-2 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding*11-04-01 1 0*

110

0.00



Large Fab

Large Fab

Memo

0.00

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898
followed by Jig
A/R AL ROD Batch: *M114703*

Grind end cap welds flush

11-04-02 1 0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 BE11/04/04

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/04

XC
21

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 RA 0 11/04/04

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

11.04.05

1

φ

QC

Memo

0.00

Quality Control

160

Large Fab

0.00

Large Fab

Memo

0.00

11.04.05

1

φ

Large Fab

Inspect for foreign object per QSI 024

Weld Remainig end cap as per Dwg D2724

A/R AL ROD Batch: 1114703

Grind end plate flush.

170

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

8 welds

W/O:		WORK ORDER CHANGES						
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

190

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 12:35

OVEN TEMPERATURE: 320°

FINISH TIME: 1:05

ⓧ
RM

1 BL 11-4-5.

1 BL 11-4-5.

W/O:		WORK ORDER CHANGES						
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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 φ All 11/04/05

220

Wing Walk as per dwg QSI005 4.4 Batch M11640200

HandFinish

Memo

0.00

Hand Finishing

1 φ All 11/04/05

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Cui/4/6 (1)

W/O:		WORK ORDER CHANGES						
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

P11P10 4617

0.00

Packaging

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

U11.0406

W/O:		WORK ORDER CHANGES						
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Page 1

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes with the objectives and goals to determine the effectiveness of the project and identify areas for improvement.



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

[REDACTED]



00000000000000000000000000000000

W/O:		WORK ORDER CHANGES						
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Picklist Print

Friday, April 01, 2011 1:41:32 PM

Page 2

Work Order ID: 67861



Parent Item: D2724-042



Parent Item Name: 206L Step Assembly

Start Date: 4/1/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

D2622-120C

Manufactured No

100

Each

34.0000

1

1



Step Extrusion



PK 11.04.01

Location

Loc Qty

Loc Code

HALL

30

64409

30

WA

4

46910

2

64409

2

Friday, April 01, 2011 1:41:32 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

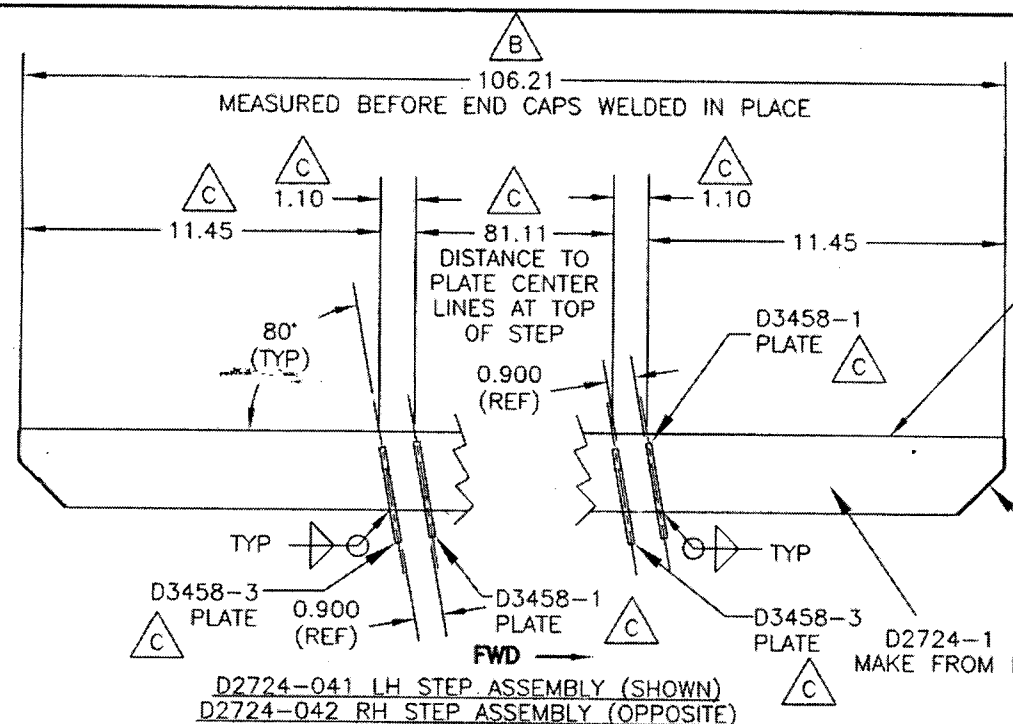
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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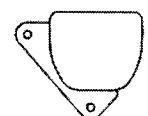
DART

RELEASED
05.11.14
67861

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

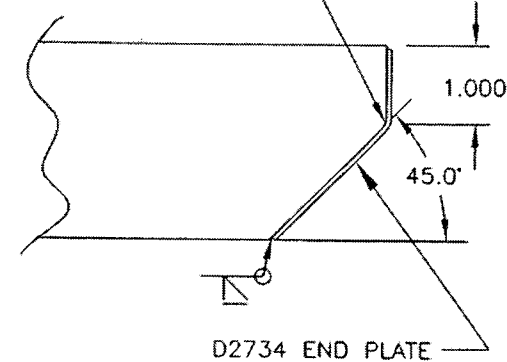


REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



D2734 END PLATE

TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN KE
DRAWN BY PH
DART AEROSPACE USA, INC.
PORT HADLOCK, WA

CHECKED
APPROVED
DRAWING NO. D2724
REV. C

DATE 05.09.19
TITLE 206L/407 STEP ASSEMBLY
SCALE NTS

A 97.12.04 NEW ISSUE

B 98.10.19 UPDATED WELD DETAIL
REVISED TOLERANCES

C 05.09.19 RE-DESIGN, ADD D3458-1/-3

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